



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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POSITIVE RECALL

EFFECTIVE 10/10/19 AUTH SMJ

RELEASED _____ DATE _____

D3370-3

Job Sheet 201333



Part No: D3370-3

Job Qty: 4 pcs

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Job Created: 10/1/19

Due Date: 10/3/19

Type: SOLD

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

Priority: Medium

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		10/3/19	0.00	0.14	Bandsaw - 1		19/10/1
110	HAAS 4 Axis - B4B	4 pcs		10/3/19	1.00	3.81	HAAS - 1 - B4B		DAS 23 9-89
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs		10/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S218851

Part: D3370-3

Job No: 201333

Serial No/Batch: S218851

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/01/19

PT.O
last page

DAS
23
9-89

130 QC 8	4 pcs	10/3/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.e 19-10-01
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	10/3/19	0.00 0.53	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 -	



				B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 6 Fire Red - B4B	4	10/3/19	0.00 0.23	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-10-2
				Powdercoat - 4 - B4B	
160 QC 3	4	10/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	DAS
				QC 3 - 17	81
				QC 3 - 18	9-89
				QC 3 - 2	
				QC 3 - 28	OCT 02 2019
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	4	10/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	58 OCT 07 2019
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	10/3/19	0.00 0.00	QC 21 - SA - 21	DAG 21
				QC 21 - SA - 70	9-52
				QC 21 - SA - 53	OCT 08 2019

Part Op 100 - (Bandsaw) Cut blank: 1.500" x 2.500" x 4.120" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3370-3 as per Folio FA483 and Dwg D3370 Identify as D3370-3
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) Heat oven at temperature for 45 minutes before putting part in oven
 by: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: ST 497)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	1.3932 ft (.3483 ea)	100-Bandsaw - 1	S207687

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	1	32	0

Part Specifications	
Specifications could not be found.	

201333

DART AEROSPACE LTD		Work Order: 200380
Description: Pedal Lock Cover		Part Number: D3370-3
Inspection Dwg: D3370	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.980	✓		Vernier	VHT-01
3.344	+/-0.010	3.346	✓		"	"
0.592	+/-0.010	0.592	✓		"	"
0.202	+/-0.010	0.202	✓		"	"
Ø1.000	+0.005/-0.000	1.000	✓		"	"
0.25	+/-0.030	0.260	✓		"	"
2.000	+/-0.010	1.9965	✓		"	"
0.300	+/-0.010	0.301	✓		"	"
0.550	+/-0.010	0.5525	✓		"	"
1.50	+/-0.030	1.4995	✓		"	"
Ø1.250	+0.005/-0.000	1.250	✓		"	"
0.635	+0.010/-0.000	0.6365	✓		"	"
Ø0.750	+0.010/-0.000	0.760	✓		"	"
1.673	+/-0.010	1.670	✓		"	"
0.430	+/-0.010	0.4265	✓		"	"
2.638	+/-0.010	2.637	✓		"	"
2.35	+/-0.030	2.348	✓		"	"
0.715 deep	+/-0.010	0.715	✓		"	"
15°	+/-0.1°	15°	✓		"	"
0.19 x 45°	+/-0.030	0.190	✓		"	"
0.450	+/-0.010	0.440	✓		"	"
1.450	+/-0.005	1.451	✓		"	"

Measured by: VHT	Audited by: A. a	Preliminary Approval:
Date: 19/9/26	Date: 19-10-01	Date:

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	
D	10.04.20	Dimensions revised per Dwg Rev C	KJ	

Entered:

2R

Date:

Mar 25/2020



NCR No.

20-8042

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: <u>201333</u> Part No. <u>D3370-3</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐																															
Date: <u>19-10-01</u>		Sequence #: <u>110</u>		QTY Affected: <u>4</u>		MRR (QSI042) DAS 51 9-89 <u>19/10/03</u>																													
Description Work Order Deviation				Disposition																															
-The 2 (8-32 UNC) holes were taped for a (8-32 UNC HELICOIL) on 4 parts				Acceptable to use Helicoil with Locktite at assembly Helicoil 8-32 batch # <u>5050047</u> MS21209C0815 Locktite B#																															
				Completed By <u>[Signature]</u> 19/10/1 Lead hand / Supervisor <u>B.</u> 19-10-01 QC / QA Coordinator DAS 55 9-89 MAR 25 2020																															
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☒ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☒ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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